

Work Order ID 130349

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Item ID: D3502-1
 Revision ID:
 Item Name: Support
 Start Date: 3/06/15 Start Qty: 40.00
 Required Date: 3/20/15 Req'd Qty: 40.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

40
40

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID / Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130 QC Quality Control	Memo	0.00		15/03/23		40	0		
140	Small Fab	0.00							DAS 36 9-89
140 Small Fab Small Fab	Memo Mark hole position using DT9430Drill as per Dwg D3502.	0.00				40x			15/03/23
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150 HandFinish Hand Finishing	Memo	0.00				40			15/03/26

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Item ID: D3502-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 3/06/15

Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/20/15

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 1503-31

PS-3-31

Picklist Print

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Work Order ID: 130349

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Parent Item: D3502-1

D3502-1

Parent Item Name: Support

Start Date: 3/06/15

Required Date: 3/20/15

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A New Issue 06-07-06 JLM

IPP Rev:B Add tooling hole 07-03-28

Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	68.0250	0.1445	7			

M6061T6B1 000X04 000

6061-T6 Bar 1.00 x 4.00

**

Location

Loc Qty

Loc Code

MAT003

68.025

→ 124681

4

M126160

20.8

→ M126351

3.7

M127797

2.925

M128980

0.6

M129167

36

4
3.7

03/15/03/14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Sub Date: 15/05/20QA Closed: 15/05/20 Date: 15/05/20

Work Order: <u>130 349</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3502-1</u>		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
NCR No. <u>15-4982</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐	15/03/18	110	4	TOP PLATE IS NOT FLAT ON ONE SIDE CAUSING THE PART TO MOVE	DAS 16 9-89	SCRAP/no replace	DAS 40 9-89		
Equip/Tooling ☒				26. machined <u>machined</u> <u>both sides</u> <u>Tooling</u>	Q2042 15/03/23	Top plate has been remachined on both side to solve problem	15/03/18	B.F.	DAS 9 9-89
Operator ☐						double checked by: B.F. 15/03/21		15/03/21	15-03-23
Material ☐								DAS 08 9-89	
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped. ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☒ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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